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(54) **Solventless, polyimide-modified epoxy composition.**

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**US-A- 4 418 166**

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## Description

The present invention relates to a process for the production of a polyimide-modified epoxy composition which does not contain unreactive solvent which must be removed during curing. It is useful as an adhesive composition.

A wide variety of adhesives are known based upon poly-modified epoxy resins in which solvent is used to insure that the adhesive composition is sufficiently castable or formable prior to curing. During the curing operation this solvent must be removed in order for the adhesive to suitably cure.

In FR-A-2355049 (US-A-4,130,600), there are disclosed storage-stable thermosetting mixtures comprising (a) polyimides, (b) epoxy compounds containing at least one allyl group and preferably selected from the epoxy compounds listed therein or mixtures thereof, (c) curing agents and/or (d) accelerators for the curing agents.

The mixtures may be cured in the melt or partly in the melt and partly in the solid phase. Reference is also made to curing the mixture in solution.

In the present invention the polyimide resin is first dissolved in a reactive monoepoxy diluent to form a solution and the epoxy resin is then added and the solution is rendered homogeneous for example by heating. This homogeneous solution which may contain a curing agent is sufficiently castable and formable prior to curing and does not contain an unreactive solvent which has to be removed during curing, thus obviating the problems incident to the removal of such extraneous solvent from adhesives known to the prior art (e.g., disposal problems, the presence of undesired voids or spaces in the cured adhesive, etc.).

According to the present invention there is provided a process for the production of a polyimide-modified epoxy adhesive composition characterised in that a polyimide resin is dissolved in a reactive monoepoxy diluent, which allows for the dissolution of the polyimide into an epoxy resin, to form a solution, an epoxy resin is added to the solution, and the solution is rendered homogeneous.

A hardener for the polyepoxy compound may be added to the homogeneous solution prepared by the process of the invention. Also the conductive filler may be added to the solution when it is used in environments where it need be conductive.

The epoxy resin component which forms an important portion of the present adhesive (5% to 90%, by weight of epoxy resin, polyimide and diluent, preferably 15% to 60%) is a conventional crosslinkable polyfunctional epoxy resin. The epoxy resins useful in this invention are those resins which contain more than one 1,2-epoxy group per molecule. They can be saturated or unsaturated aliphatic, cycloaliphatic or heterocyclic groups and can be monomeric or polymeric in nature. The weight per epoxide of such resins can be within the range of 100 to 2,000.

Useful epoxy resins are the glycidyl polyethers of polyhydric phenols which are derived from an epihalohydrin, e.g., epichlorohydrin, and a polyhydric phenol. Examples of such polyhydric phenols include resorcinol, hydroquinone, bis(4-hydroxyphenyl)-2,2-propane (or bisphenol A as it is commonly called), 4,4'-dihydroxybenzophenone, bis(4-hydroxyphenyl)-1,1-ethane, bis (4-hydroxyphenyl)-1,1-isobutane, bis(4-hydroxyphenyl)2,2-butane, bis(2-dihydroxynaphthyl) methane, phloroglucinol, and bis(4-hydroxyphenyl) sulfone. Additional polyhydric phenols are novolac resins containing more than two phenol, or substituted phenol, moieties linked through methylene bridges, as well as halogenated, e.g., brominated and chlorinated, phenolic compounds.

Additional epoxy resins are glycidyl polyethers of polyhydric alcohols prepared by reacting a polyhydric alcohol with an epihalohydrin using an acidic catalyst, e.g., boron trifluoride, and subsequently treating the resulting product with an alkaline dehydrohalogenating agent. Included among the polyhydric alcohols that can be used in the preparation of these polyepoxy materials are glycerine, ethylene glycol, propylene glycol, diethylene glycol, hexanediol, hexanetriol, trimethylol propane, trimethylol ethane, pentaerythritol, and the like.

Other epoxy resins are glycidyl esters of polycarboxylic acids which are derived from an epihalohydrin and a polycarboxylic acid. Examples of polycarboxylic acids include phthalic acid or its anhydride, isophthalic acid, terephthalic acid, tetrahydrophthalic acid, hexahydrophthalic anhydride, adipic acid, dimerized fatty acids, dibasic acids made from an unsaturated fatty acid and acrylic acid, and the like.

The most preferred epoxy resins are glycidyl polyethers of polyhydric phenols, particularly the glycidyl polyether of bisphenol A and epoxylated phenol or cresol novolac resins.

The soluble polyimide component is present in an amount of 0.1% to 20%, by weight of epoxy, polyimide and diluent, preferably 1% to 10%. The type of polyimide resins described in U.S. Patent No. 3,856,752 to J. Bateman et al. which are commercially available from Ciba-Geigy Corporation, e.g., under the trademark XU218, are suitable resins which can be utilized. These are fully imidized polyimide resins which are soluble in various solvents. They are derived from phenylindane diamines and dianhydrides as

described more fully in the above-referenced U.S. patent which is incorporated herein by reference. The polyimides are prepared by reacting a phenylindane diamine with a dianhydride in an organic reaction medium which is a solvent for at least one of the reactants, preferably under anhydrous conditions under 100°C. The resulting product is a polyamide acid which is then converted to the desired polyimide by one of several methods: heating the polyamide acid solution until imidization is substantially complete; or by combining the polyamide acid solution and a dehydrating agent, with or without catalyst, and optionally heating the resulting mixture until imidization is substantially complete.

In order to assure dissolution of the above-identified polyimide resin into the epoxy resin component, the present invention contemplates the use of from about 5% to about 60%, by weight of epoxy, polyimide and diluent, preferably 10 - 40%, of the reactive monoepoxy diluent as a reactive material which functions as a solvent prior to curing but which after curing becomes an integral part of the cured adhesive matrix. These reactive monoepoxy diluents contain an epoxide group at one end of the molecule linked to an aryl substituent. Representative examples of reactive epoxy diluents which can be used include styrene oxide, phenyl glycidyl ether, and cresyl glycidyl ether. These compounds exhibit a good solubility characteristic toward the polyimide resin and the epoxy resin.

An optional component of the unfilled adhesive compositions of the present invention is from about 0.5% to about 80%, by weight of the weight of hardener plus adhesive, preferably 2% to 60%, of a conventional hardener for the type of polyepoxy component which is described above. If a person wished to make a curable adhesive which, when combined with the hardener would be curable, they could eliminate the hardener from the composition they sell. This type of hardener acts by crosslinking the epoxy resin and also reacts with the monoepoxy diluent to cure the system. It can be added to the aforementioned curable adhesive by the end user, if desired.

Representative curing agents include aliphatic polyamines having at least three active amine hydrogen atoms per molecule. Examples of such amines are the polyalkylene polyamines, e.g., diethylene triamine, triethylene tetraamine, tetraethylene pentamine and pentaethylene hexamine. Additional useful amines are ethylene diamine, tetramethylene diamine, hexamethylene diamine, xylene diamine, and the like. Adducts of such amines with acrylonitrile, acrylic acid, ethyl acrylate and the like are also useful if the adduct contains at least three active amine hydrogen atoms. Also included as useful amines are amidoamines obtained by reacting polyamines with fatty acids, both monomers and dimers, provided of course that the resulting amidoamine contains at least three active amine hydrogen atoms per molecule.

Additional curing agents which can be used with the compositions of this invention include the amine terminated polyamides, aromatic amines, mercaptans, anhydrides, isocyanates, and catalyst/latent hardeners such as boron trifluoride-monoethylamine and dicyandiamide.

Representative aromatic amines include metaphenylene diamine, 4,4'-methylenediamine, p-aminophenyl sulfone, benzyldimethylamine, and the like. Exemplary anhydride curing agents are NADIC METHYL ANHYDRIDE brand curing agent (methyl-bicyclo[2.2.1]heptene-2,3-dicarboxylic anhydride isomers), hexahydrophthalic anhydride, phthalic anhydride, pyromellitic dianhydride, maleic anhydride, trimellitic anhydride, benzophenone tetracarboxylic dianhydride, chlorendic anhydride, and dodecenylsuccinic anhydride.

The type of curable resin composition which is formed using these four materials as its constituent elements has utility in various bonding applications where high temperature characteristics are important. For example, metal-to-metal bonding and plastic bonding in high temperature environments are examples of where the adhesive can find utility.

If a conductive adhesive composition having good high temperature properties is desired, e.g., for semiconductor die bonding to chip carriers, the aforementioned curable adhesive composition can be modified by the addition of a sufficient amount of conductive filler to give the desired conductivity characteristics to the final product. If the conductive filler is used, it will generally be a major portion of the resulting adhesive, e.g., from 50% to 75% by weight of the aforementioned adhesive (including hardener, if desired) and conductive filler component. Other fillers, pigments and dyes may be incorporated. The fillers may be in the form of particles or fibers. Typical fillers include ground ceramics, silica, mica, treated clays, titanium dioxide, graphite, carbon black, glass fibers, and metal powders such as copper, aluminum, silver, and gold.

The present invention is further illustrated by the Examples which follow which give certain preferred embodiments for the adhesive of the present invention.

#### EXAMPLE 1

Polyimide resin (CIBA-GEIGY XU 218 brand), 0.15 g, was dissolved in 0.8 g of phenyl glycidyl ether at

130° C. To this was added 1.9 g of epoxy resin (SHELL EPON 828 brand), and heating was continued to obtain a homogeneous solution. At about 60° C. the solution was mixed with 0.14 g of 2-ethyl-4-methyl imidazole epoxy curing agent in 0.4 g of phenyl glycidyl ether. The composition was cured by heating at 80° C. for 1 hour and then at 150° C. for 3 hours. When cured between two glass slides, it gave strong glass to glass bonding. Thermogravimetric analysis of the cured composition showed a weight loss of 7% at 400° C. in air. For comparison, the composition containing no polyimide showed a 9% weight loss at the same temperature.

#### EXAMPLE 2

Polyimide resin (CIBA-GEIGY XU 218 brand), 1.0 g, was dissolved in 5.0 g of styrene oxide at 120° C. To this was added 12.0 g of novolac epoxy resin (CIBA-GEIGY ECN 1235 brand), and heating was continued to obtain a homogeneous solution. The solution had a Brookfield viscosity of 10,000 mPa.s (10,000 cps) at 25° C. At about 60° C., 1.0 g of the solution was mixed with 0.20 g of p-aminophenyl sulfone curing agent. The composition was cured by heating at 150° C. for 4 hours. When cured between two glass slides, it gave strong glass to glass bonding. Thermogravimetric analysis of the cured composition showed a weight loss of 5% at 400° C. in air.

#### EXAMPLE 3

Polyimide resin (CIBA-GEIGY XU 218 brand), 1.0 g was dissolved in 5.0 g of phenyl glycidyl ether at 120° C. To this was added 10.0 g of novolac epoxy resin (CIBA-GEIGY ECN 1235 brand), and heating was continued to obtain a homogeneous solution. The solution had a Brookfield viscosity of 42,000 mPa.s (42,000 cps) at 25° C. At about 60° C., 1.0 g of the solution was mixed with 0.20 g of p-aminophenyl sulfone curing agent. The composition was cured by heating at 150° C. for 4 hours. When cured between two glass slides, it gave yielded strong glass to glass bonding. Thermogravimetric analysis of the cured composition showed a weight loss of 7% at 400° C. in air.

#### EXAMPLES 4 TO 7

Following the procedure of Example 3, an epoxy resin (SHELL EPON 828 brand) containing various amounts of polyimide (CIBA-GEIGY XU 218 brand) were prepared and cured with a NADIC METHYL ANHYDRIDE brand/ethyl methyl imidazole curing agent combination. When cured at 150° C. for 1.5 hours, all gave strong glass to glass bonding. Variation in the compositions and the results of the thermal analysis of the cured compositions are shown in Table 1 which follows:

TABLE 1

		<u>EXAMPLE NO.</u>	
<u>INGREDIENTS</u>		<u>4*</u>	<u>5</u>
Polyimide resin (CIBA-GEIGY XU 218),g.		0	1
Phenyl glycidyl ether, g.		10	10
Epoxy resin (SHELL EPON 828 brand),g.		10	10
Viscosity,mPa.s (cps) at 25° C.		50	650
<u>Curing agents:</u>			
NADIC METHYL ANHYDRIDE brand,g.		10	10
5% EMI** in phenyl glycidyl ether, g.		0.5	0.5
Weight loss(%) at 400° C.		33	30

\* not part of the present invention. Present for comparison only.

\*\* 1,2-ethyl-4-methyl imidazole.

TABLE 1 (CONT'D)

5	INGREDIENTS	EXAMPLE NO.	
		<u>6</u>	<u>7</u>
	Polyimide resin (CIBA-GEIGY XU 218), g.	2	3
10	Phenyl glycidyl ether, g.	10	10
	Epoxy resin (SHELL EPON 828 brand), g.	10	10
15	Viscosity, mPa.s (cps) at 25° C.	6600	25000
	<u>Curing agents:</u>		
20	NADIC METHYL ANHYDRIDE brand, g.	10	10
	5% EMI ** in phenyl glycidyl ether, g.	0.5	0.5
25	Weight loss(%) at 400° C.	26	28
30	** 1,2-ethyl-4-methyl imidazole.		

The above data illustrate less weight loss for the products of Examples 5 - 7 as compared to Example 4 with an increase in viscosity.

#### EXAMPLE 8

Polyimide resin (CIBA-GEIGY XU 218 brand), 1.0 g, was dissolved in 7.0 g of phenyl glycidyl ether at 120° C. To this was added 10.0 g of novolac epoxy resin (CIBA-GEIGY ECN 1235 brand), and heating was continued to obtain a homogeneous solution. This was cooled to 70° C., and mixed with 15.0 g. of NADIC METHYL ANHYDRIDE curing agent and 0.1 gm. of 2-ethyl-4-methyl imidazole in 3.0 g. of phenyl glycidyl ether. The solution had a Brookfield viscosity of about 1400 mPa.s (1400 cps) at 25° C. Twenty-five grams of the composition of the solution was then mixed with 50 g. of silver flake (Handy & Harman SILFLAXE 235 brand) and 2 g. of phenyl glycidyl ether to give a silver filled epoxy resin. Thermogravimetric analysis of the composition cured at 80° C. for thirty minutes and 150° C. for one hour showed a weight loss of 5% at 400° in air. The composition exhibited strong silicon chip to glass bonding.

#### EXAMPLE 9

This example shows the shear strength of a die (size: 1.29 cm. x 1.29 cm.) bonded to a lead frame using the adhesive described in Example 8. The adhesive thickness was 17.8 micrometers (0.7 mil). The adhesive was first "B-staged" (partially cured) at 67°C. for 20 min. and then more fully cured at 150°C. for 30 min. Die shear strength was tested with a Chatillon force gauge by pushing the die sideways. The force required to dislodge each die was recorded.

TABLE 2

Lead Frames	Die Shear Strength(kg)
gold*-plated alloy 42**	10.0
silver*-plated copper	14.0
silver*-plated alloy 42**	14.4
plain copper	8.6
alloy 42**	11.3

\*thickness 15 micrometers.

\*\*alloy 42 is an alloy of 42% nickel with substantially all the remainder comprising iron.

The foregoing Examples are intended to illustrate certain embodiments of the present invention but should not be construed in a limiting sense. The scope of protection sought is set forth in the Claims which follow.

### Claims

1. A process for the production of a polyimide-modified epoxy adhesive composition characterised in that a polyimide resin is dissolved in a reactive monoepoxy diluent, which allows for the dissolution of the polyimide into an epoxy resin, to form a solution, an epoxy resin is added to the solution, and the solution is rendered homogeneous.
2. A process as claimed in claim 1 characterised in that the epoxy resin comprises from 5% to 90%, by weight of the composition.
3. A process as claimed in claim 1 or claim 2 characterised in that the soluble polyimide resin comprises from 0.1% to 20% by weight of the composition.
4. A process as claimed in any of claims 1 to 3 characterised in that the reactive monoepoxy diluent comprises from 5% to 60% by weight of the composition.
5. A process as claimed in any of claims 1 to 4 characterised in that a conductive filler is also added to the homogeneous solution.
6. A process as claimed in claim 5 characterised in that from 50% to 75%, by weight of the entire composition, of the conductive filler, is added to the homogeneous solution.
7. A process as claimed in claim 6 characterised in that from 0.5% to 80%, by weight of a hardener for the epoxy resin, based on the weight of hardener and adhesive is added.
8. A process as claimed in any of claims 1 to 7 including the further step of curing the composition.

### Revendications

1. Un procédé pour la production d'une composition adhésive époxydique modifiée par un polyimide, caractérisé en ce qu'une résine de polyimide est dissoute dans un diluant monoépoxydique réactif, ce qui permet la dissolution du polyimide dans une résine époxydique, afin de former une solution, une résine époxydique est ajoutée à la solution, et la solution est rendue homogène.
2. Un procédé tel que revendiqué à la revendication 1, caractérisé en ce que la résine époxydique représente de 5% à 90% en poids de la composition.
3. Un procédé tel que revendiqué à la revendication 1 ou la revendication 2, caractérisé en ce que la résine de polyimide soluble représente de 0,1% à 20% en poids de la composition.

4. Un procédé tel que revendiqué à l'une quelconque des revendications 1 à 3, caractérisé en ce que le diluant monoépoxydique réactif représente de 5% à 60% en poids de la composition.
5. Un procédé tel que revendiqué à l'une quelconque des revendications 1 à 4, caractérisé en ce qu'une charge conductrice est également ajoutée à la solution homogène.
6. Un procédé tel que revendiqué à la revendication 5, caractérisé en ce que de 50% à 75% en poids, sur la base de la composition totale, de la charge conductrice, sont ajoutés à la solution homogène.
7. Un procédé tel que revendiqué à la revendication 6, caractérisé en ce que de 0,5% à 80% en poids d'un durcisseur pour la résine époxydique, sur la base du poids du durcisseur et de l'adhésif, sont ajoutés.
8. Un procédé tel que revendiqué à l'une quelconque des revendications 1 à 7, comprenant l'étape supplémentaire de durcissement de la composition.

#### Patentansprüche

1. Verfahren zur Herstellung einer polyimidmodifizierten Epoxidharzklebstoffzusammensetzung, dadurch gekennzeichnet, daß ein Polyimidharz in einem reaktiven Monoepoxidverdünnungsmittel gelöst wird, was das Lösen des Polyimids in einem Epoxidharz zur Bildung einer Lösung ermöglicht, daß ein Epoxidharz zu der Lösung hinzugegeben und die Lösung homogen gemacht wird.
2. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß das Epoxidharz 5 bis 90 Gew.-% der Zusammensetzung umfaßt.
3. Verfahren nach Anspruch 1 oder 2, dadurch gekennzeichnet, daß das lösliche Polyimidharz 0,1 bis 20 Gew.-% der Zusammensetzung umfaßt.
4. Verfahren nach irgendeinem der Ansprüche 1 bis 3, dadurch gekennzeichnet, daß das reaktive Monoepoxidverdünnungsmittel 5 bis 60 Gew.-% der Zusammensetzung umfaßt.
5. Verfahren nach irgendeinem der Ansprüche 1 bis 4, dadurch gekennzeichnet, daß auch ein leitfähiges Füllmittel zur homogenen Lösung hinzugegeben wird.
6. Verfahren nach Anspruch 5, dadurch gekennzeichnet, daß zur homogenen Lösung 50 bis 75 Gew.-% des leitfähigen Füllmaterials, bezogen auf die Gesamtzusammensetzung, gegeben werden.
7. Verfahren nach Anspruch 6, dadurch gekennzeichnet, daß 0,5 bis 80 Gew.-% eines Epoxidharzhärters, bezogen auf das Härter- und Klebstoffgewicht, hinzugegeben werden.
8. Verfahren nach irgendeinem der Ansprüche 1 bis 7, daß es den weiteren Schritt der Vernetzung der Zusammensetzung einbezieht.